

Shy April 12

Work Order ID 81570

81570

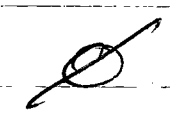
Page 1

March-15-12 1:00:34 PM

Item ID: D3265-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Basket Base Assembly
 Start Date: 15/03/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 13/04/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/15 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3265	Rev C								
100	Weld per dwg A/R S.S. rod Batch: <u>118366</u>	0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Drill hole in D3265-3 as per Dwg D3265 ****ONLY DRILL WHEN ASSEMBLING WITH D3267-041/-043 LID, AS PER SHEET 2 NOTE 10 *** 2-Remove all markings from material 3-Weld as per Dwg D3265 using DT9444 Deburr as required 4-cut mesh								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

1x  12.04.13

12.10.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81570

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing <i>Atomic L</i> Memo	0.00 0.00		8126415		<i>IX</i>	<i>IX</i>		<i>M-L</i> 12/04/16

130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				<i>IX</i>	<i>IX</i>		<i>M-L</i> 12/04/16
---	--	------	--	--	--	-----------	-----------	--	------------------------

Memo

1ST COAT:

START TIME: 10:50

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:20

****if necessary****

2ND COAT:

START TIME: 11:20

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:50

W 121134

W/O:		WORK ORDER CHANGES					
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Work Order ID 81570***81570***

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March-15-12 1:00:34 PM

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Base Assembly

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

(12)

EP 12/04/16

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

Seal support gusset seam with White Sikaflex-291

Batch: M119508

Expiry date: 12/08/13

(12)

EP 12/04/16

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

S 12/04/16

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Page 4

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Revision ID:

Item Name: Basket Base Assembly

Stop ***NS2***

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: **GA**

0.00

170

Packaging

Memo

**w/o
81563**

0.00

(12)**12/04/16**

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/17
ME
12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March-15-12 1:00:40 PM

Page 1

Work Order ID: 81570

81570

Parent Item: D3265-041

D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Re-Format 05-11-03 JLM
 IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC IPP
 RevE: as per DEO DD 10.09.12 verified by:EC IPP RevF: revise seq
 110 DD 10.01.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3		Manufactured	No			100	Each	10.0000	2	2			
D2232-3									**				
Basket Hinge													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		10							
				75581		2							
				78903		8		B78903		2			
D2235-1		Manufactured	No			100	Each	19.0000	1	1			
D2235-1									**				
Basket Rib													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				78636		5							
				WA005		14							
				66895		4							
				79153		10							
D2327-3		Manufactured	No			100	Each	44.0000	2	2			
D2327-3									**				
Spacer Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		22							
				79333		22							
				WA005		22							
				75564		1							
				77229		1							
				81144		20							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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March-15-12 1:00:40 PM

Page 2

Work Order ID: 81570

81570

Parent Item: D3265-041

D3265-041

Parent Item Name: Basket Base Assembly

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

27.0000

2

2

D2581

Mounting Bracket

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA005

27

69739

1

70766

2

77045

1

77523

23

B81253

2

D3442-5

Manufactured No

100

Each

26.0000

4

4

D3442-5

Shim

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA005

26

33282

26

D3826-041

Manufactured No

100

Each

2.0000

2

2

D3826-041

Rib / Gusset Assembly

**

PL 12-04-16

Location

Loc Qty

Loc Code

WA005

2

77676

2

D3833-1

Manufactured No

100

Each

9.0000

2

2

D3833-1

Mesh (Base End Face)

**

PL 12-04-16

Location

Loc Qty

Loc Code

WA

7

77621

7

WA035

2

79335

2

~~2~~
2

March-15-12 1:00:40 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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March-15-12 1:00:40 PM

Page 3

Work Order ID: 81570

Parent Item: D3265-041

Parent Item Name: Basket Base Assembly

81570

D3265-041

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

711.9496

26

27.36842

M304EX0 75-16F

Expanded Metal Flat SS

**

SAD 12-04-05

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

711.9494457

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

2.97557478

120318

39.8113116

120917

295.94

M304TS0.750W.065

Purchased

No

100

f

664.5479

18.3

19.26316

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

27.3685
SAD 12-04-05

Location

Loc Qty

Loc Code

MAT017

616.890429

120267

116.890429

120633

500

MAT018

41

7636

41

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

M121870

19.2632

Dart Aerospace Ltd

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NOTE: Date & initial all entries

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
2	D2232-3	HINGE PLATE
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D2327-3	BUSHING
2	D2581	MOUNTING BRACKET
2	D3265-1	RIB
2	D3265-3	RIB
2	D3265-5	RIB
2	D3442-5	SHIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81570 MCT
12/03/15

DEO ATTACHED

RELEASED
08.09.11/11



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHT 4 ADDED. RIB MATERIAL WAS 0.060 THICK. SHT 2 ZONE D5 25.63 DIMENSION WAS 27.63.	AJS	08.08.14
B	INCORPORATED A1. ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS.	PH	05.06.08
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3265	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

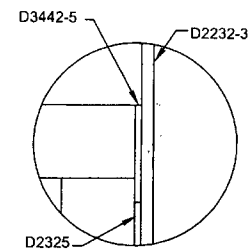
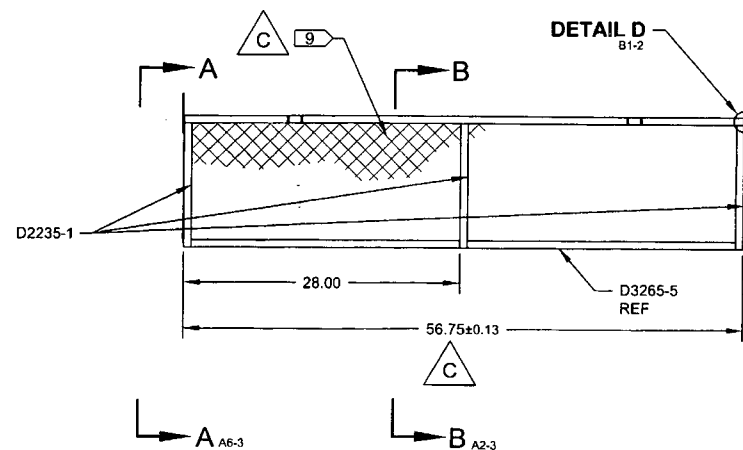
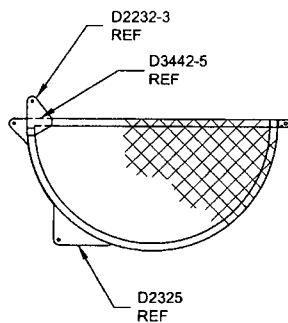
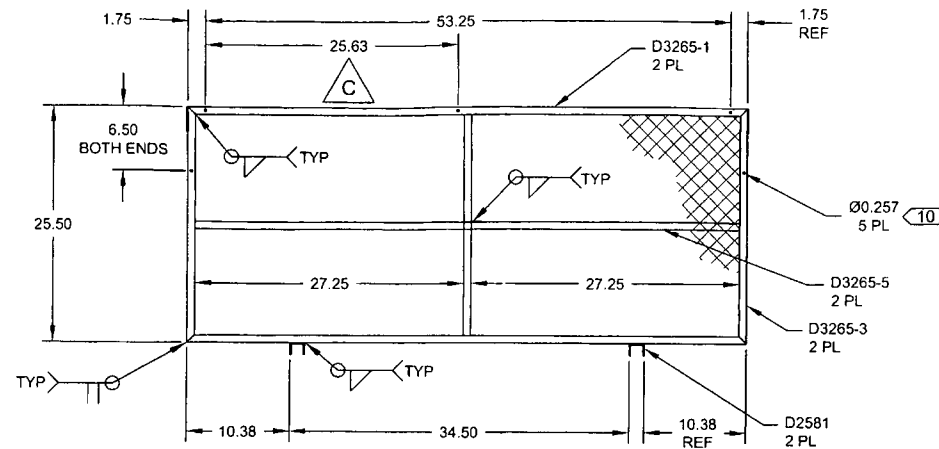
5

4

3

2

1



DETAIL D C4-2
(BOTH ENDS)
SCALE 10X



BASE ASSEMBLY NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) SKIN INSIDE SURFACE OF BASKET WITH EXPANDED STEEL MESH.
TACK WELD EACH END OF STRAND TO FRAME.
- 10) DRILL WHEN ASSEMBLING WITH D3267-041/-043 LID ONLY.

D3265-041 BASKET BASE ASSEMBLY

DEO ATTACHED
RELEASED
08-07-14

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	• HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. C
MFG. APPR.	RE	D3265	SHEET 2 OF 4
APPROVED	RE	TITLE	SCALE
DE APPR.	RE	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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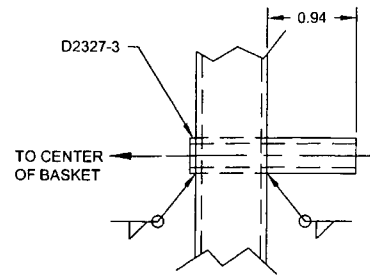
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

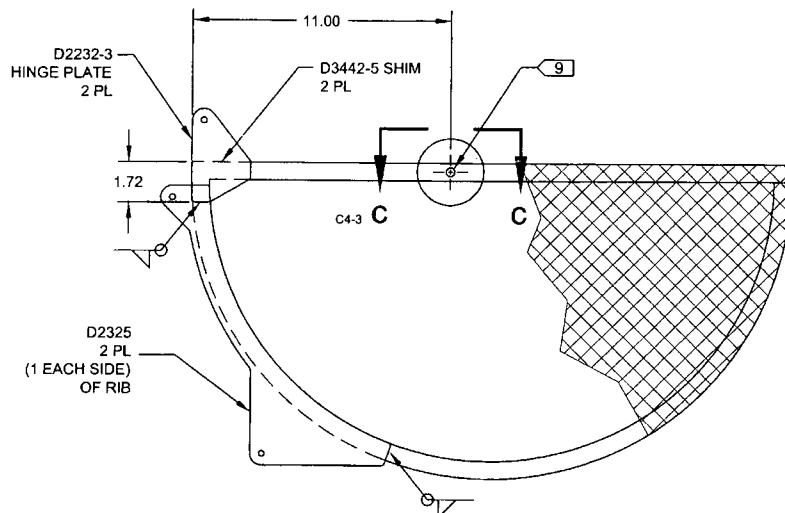
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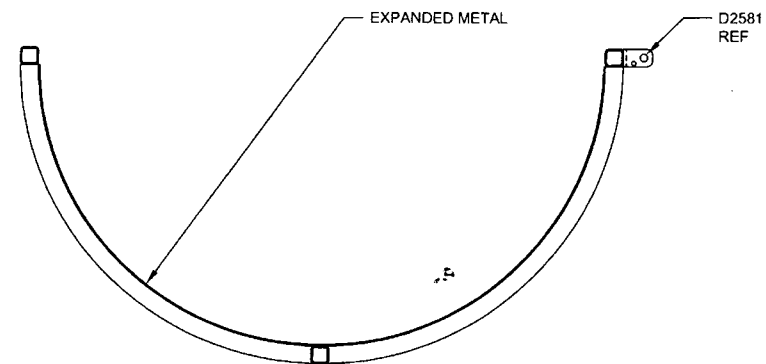
81570



VIEW C-C B7-3
2 PL
SCALE 4X
ROTATED 90° CCW



SECTION A-A A5-2
2 PL
(BOTH END RIBS)



SECTION B-B A4-2
2 PL
(BOTH CENTER RIBS)

NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-3 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS

DEO ATTACHED
RELEASED
28-09-04/118

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3265	SHEET 3 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSEMBLY (350)	NTS
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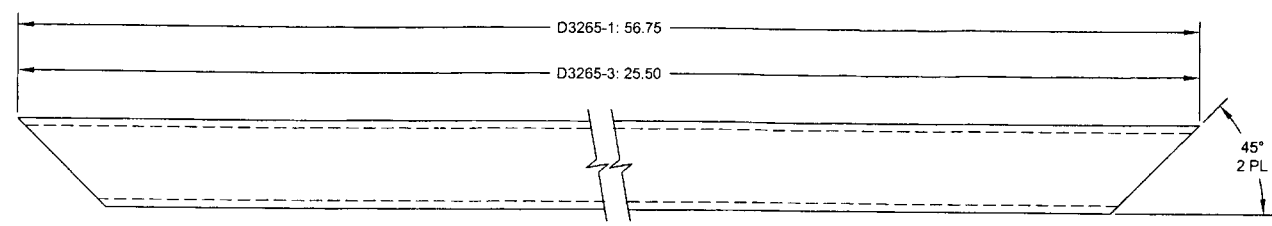
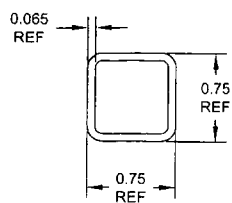
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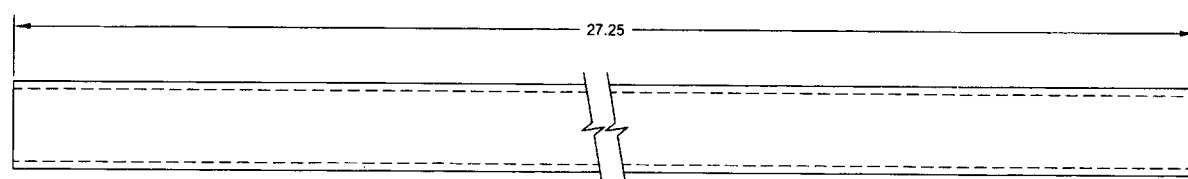
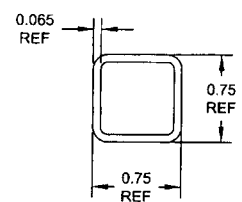
NOTE: Date & initial all entries

81570



D3265-1 RIB

D3265-3 RIB



D3265-5 RIB

DEO ATTACHED
RELEASED

- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3265	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3265-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED <i>PH</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09.04.16	DATE 09.04.16		DATE 09.04.16		

SHEET 1, MODIFY PARTS LIST AS FOLLOWS:

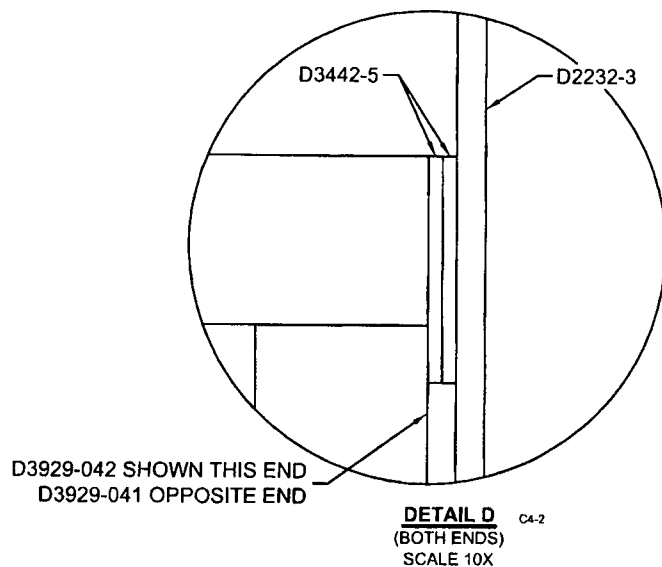
IS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
3	D2235-1	RIB
2	D3929-041	GUSSET ASSEMBLY
2	D3929-042	GUSSET ASSEMBLY
4	D3442-5	SHIM

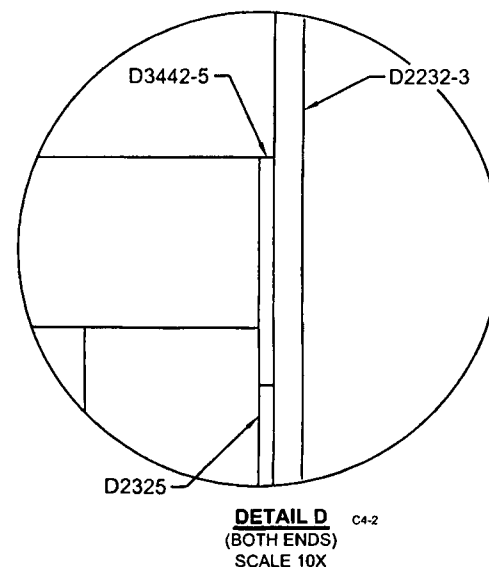
WAS:

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D3442-5	SHIM

SHEET 2, MODIFY DETAIL D AS SHOWN:



RELEASED
21/04/22



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

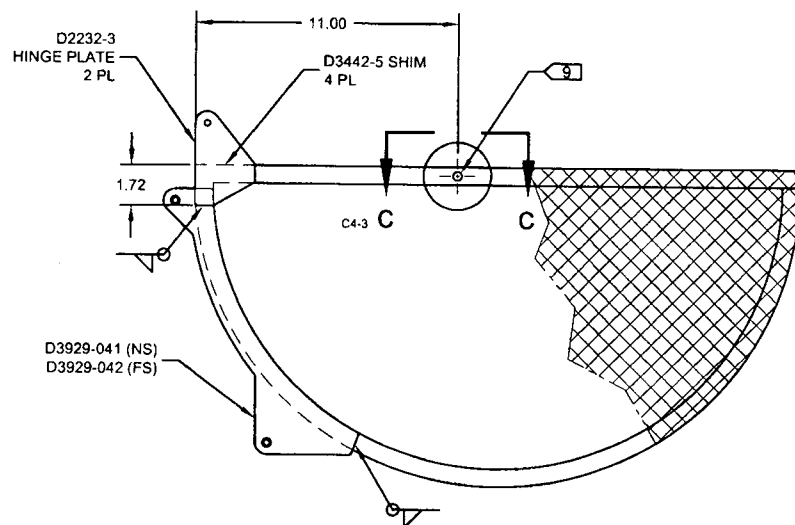
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3265	TITLE BASKET BASE ASSEMBLY (350)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3265-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>LB</i>	CHECKED <i>PH</i>	MFG. APPR. <i>AD</i>	APPROVED <i>TH</i>	DE APPR. <i>TH</i>		
DATE 09.04.16	DATE 09.04.16	DATE 09/04/17	DATE 09.04.17	DATE 09.04.17		

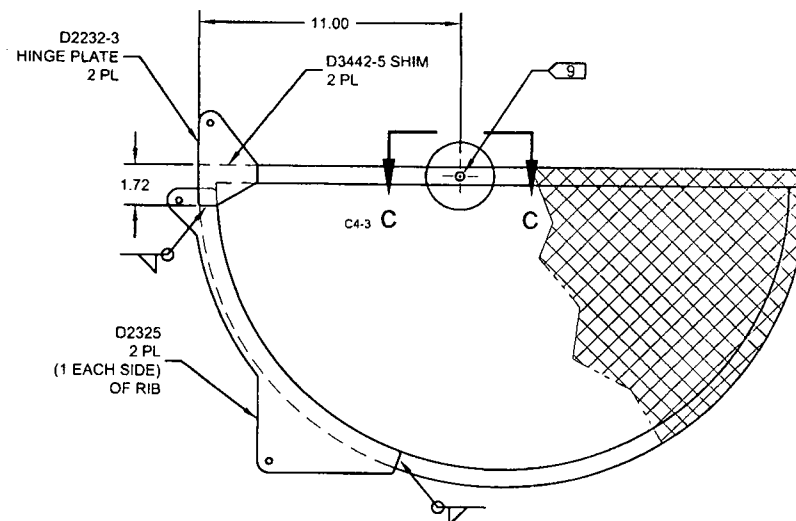
SHEET 3, MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A A5-2
2 PL
(BOTH END RIBS)

WAS:



SECTION A-A A5-2
2 PL
(BOTH END RIBS)

RELEASED
09/04/17

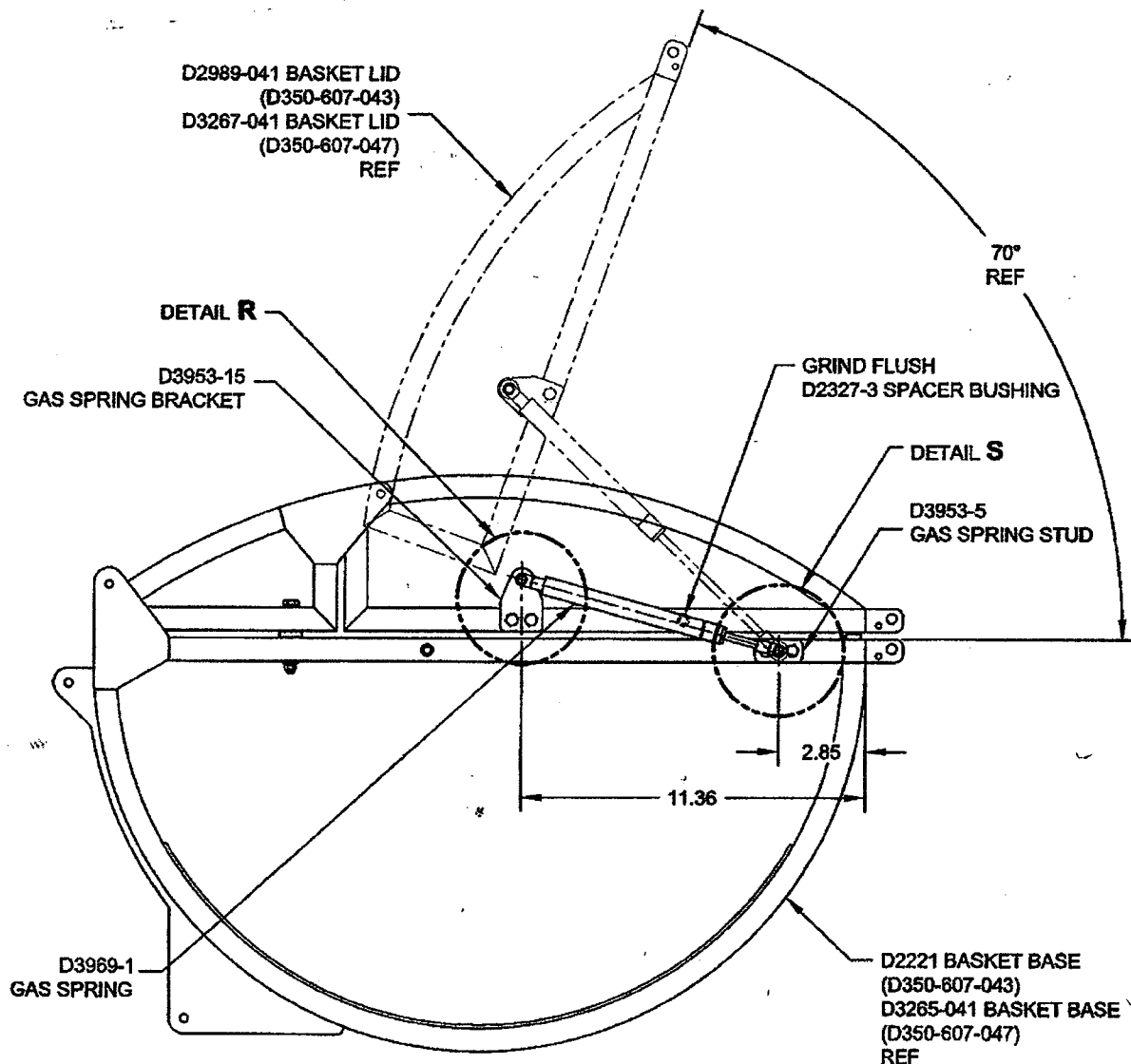
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-607-143 AUTOMATIC LID OPENER INSTALLATION
(1 END ONLY)

Figure 9a – Automatic Lid Opener Installation

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Revision: **A**
Date: 10.03.10

- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.



4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T.
- 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.